

Work Order ID 136787

September 08, 2015 1:17:02 PM

D350-615-041
D350-615-041
136787
REV. B

136787

To ship Sept 17/15.
50123035

Page 1

Item ID: D350-615-041

Revision ID:

Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015 Start Qty: 10.00

Required Date: 9/16/2015 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: Sth Date: 20150908
QC: Date: SPC (Y/N):

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D350-615-041	B

100	Document Control	0.00				DAS 27 9-89			
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100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
as per PPP D350-615-041 CHG003

110

110

Small Fab

Small Fab

Memo

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***

10 FF NOV 02 2015

120

120

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

10

DAS
38
9-89

NOV 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 136787

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136787

Page 2

Item ID: D350-615-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: GHW Modification, Fits LH or RH
 Start Date: 9/8/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 9/16/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC4- 100% Inspect kits for completeness	0.00					27		
130							9-89		
QC	Memo	0.01				10			
Quality Control									
140		0.00							
140									
Packaging	Memo	0.00							
Packaging	Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.02							
Quality Control									

NOV 03 2015

NOV 03 2015

NOV 03 2015

NOV 03 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

September 08, 2015 1:17:30 PM

Page 1

Work Order ID: 136787

136787

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015

Required Date: 9/16/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-041		Manufactured	No			110	Each	1.0000	1	10			
D2282-041									**				
T Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			DAS
				GA				1					6
					130708			1					9-89
D2282-043		Manufactured	No			110	Each	10.0000	1	10			
D2282-043									**				
Saddle Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			DAS
				GA				10					30
					110681			6		B 136789			9-89
					110847			4					
5/16-18-015C		Purchased	No			110	Each	33.0000	3	30			
5/16-18-015C									**				
SS Bolt 5/16-181.5"K													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			DAS
				st572				33					05
					m131962			33					9-89

137286 Y10

OCT 26 2015

133171 X27

OCT 08 2015

Picklist Print

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Work Order ID: 136787

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Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015

Required Date: 9/16/2015

Start Qty: 10.00

Required Qty: 10.00

D3015-3 Manufactured No 110 Each 75.0000 3 30

D3015-3

Locknut

**

136803x7

DAS
08
9-09

Location	Loc Qty	Loc Code
FG	18	
95758	8	
96151	10	
ST015	57	
129764	4	
132485	53	

23

5/16WC Purchased No 110 Each 120.0000 12 120

5/16WC

Washer

**

132171 96

DAS
08
9-09

Location	Loc Qty	Loc Code
st572	120	
m131961	120	

M133503

24

DAS
27
9-89

7/16-14-050C Purchased No 110 Each 10.0000 1 10

7/16-14-050C

SS Bolt 7/16 5"K Long (92198A672)

**

133197

DAS
08
9-09

Location	Loc Qty	Loc Code
ST571	8	
m131934	8	
st572	2	
120146	2	

D3015-5 Manufactured No 110 Each 42.0000 1 10

D3015-5

SS Nylock Nut 7/16

**

Location	Loc Qty	Loc Code
ST015	42	
99599	42	

10

OCT 08 2015

DAS
08
9-09

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 136787

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Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015

Required Date: 9/16/2015

Start Qty: 10.00

Required Qty: 10.00

7/16WC

Purchased

No

110

Each

106.0000

2

20

7/16WC

**

Washer, SS Flat 7/16

Location

Loc Qty

Loc Code

DAS

st572

106

20

6

120508

106

9-89

NOV 04 2015

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D350-615-041
B 136787
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Page 1

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Revision ID:

Item Name: GHW Modification, Fits LH or RH

Start Date: 9/8/2015 Start Qty: 10.00

Required Date: 9/16/2015 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: SH

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Cust Item ID:

Customer:

Run Start

Stop

NR1

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D350-615-041	B

100 Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
as per PPP D350-615-041 CHG003

MLS NOV 03 2015

(10)

110

0.00

110

Small Fab

Memo

0.02

Small Fab

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
one thread on three 5/16-18-015C bolts***

10 FF NOV 02 2015

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(10)

DAS
38
9-89

NOV 02 2015